

Work Order ID 138856***138856***

Page 1

Friday, November 13, 2015 11:35:11 AM

Item ID: D5123-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Clamp Cushion

Start Date: 11/10/2015 Start Qty: 24.00

24

Cust Item ID:

Required Date: 11/13/2015 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals: Process Plan: MLJ Date: NOV 13 2015

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5123	C								

100

0.00

100

Mill Conv

Memo

0.08

Conventional Milling Machine

1-Mill as per DWG

DWG REV: C

2-Deburr as required

24ØJ.C.L. 11/12/03

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.01

Quality Control

24ØJ.C.L. 11/12/03

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Page 2

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Item ID: D5123-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clamp Cushion

Start Date: 11/10/2015 Start Qty: 24.00

24

Cust Item ID:

Required Date: 11/13/2015 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							DAS 08 9-89
120									
QC	Memo	0.01							
Quality Control									
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging	LOCATION: LG054								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.04							
Quality Control									

24 DEC 07 2015

ML5 DEC 08 2015

ML5 DEC 07 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Misidentified ☐	Past Due ☐								

Picklist Print

Friday, November 13, 2015 11:35:11 AM

Page 1

Work Order ID: 138856

138856

Parent Item: D5123-1

D5123-1

Parent Item Name: Clamp Cushion

Start Date: 11/10/2015

Required Date: 11/13/2015

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP REV:A NEW ISSUE 14/08/08 JLM VERIFIED BY:RQ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4287-1		Manufactured	No				f	64.8840		10.35789			

D4287-1

Uhmw U-Channel

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST479a	57.218	
135952	1.218	
138255	16	
138585	40	
ST499	7.666	
136921	7.666	

10.249'

2.583'

7.666'

J.C.-L. 11/11/25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

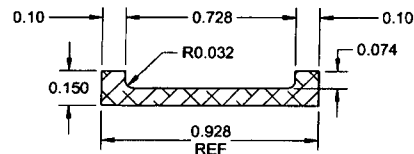
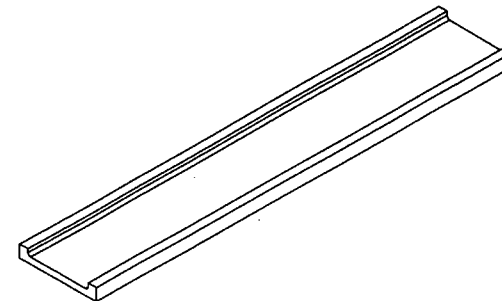
QA Closed: _____ Date: _____

Work Order update only ☐

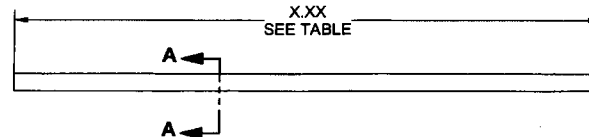
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SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO CHANGE
 WITHOUT NOTICE
 WORK IN PROGRESS

NO. 138856 MLS
 15-11-13



SECTION A-A
 SCALE 2X



D5123-Y CLAMP CUSHION

PART NUMBER	LENGTH X.XX (IN)
D5123-1	5.00
D5123-3	4.25
D5123-5	6.00
D5123-7	3.95



RELEASE

2015 MAR 18

ECN 15-547

NOTES:

- 1) MATERIAL: MAKE FROM D4287-1
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.7
- 7) WEIGHT: LESS THAN 0.01 lbs

C	ADD D5123-7	CP	15.01.21
B	ADDED D5123-5 CLAMP CUSHION, ADDED TABLE, ADDED THICKNESS TO PART	AP	14.08.19
A	NEW ISSUE	AP	14.08.08
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D5123 TITLE CLAMP CUSHION SCALE NTS SHEET 1 OF 1 REV. C DATE 15.01.21	
DRAWN	CP		
CHECKED	AP		
MFG. APPR.	JLM		
APPROVED	HS		
DE APPR.	DS		
DATE	15.01.21	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED